











Date: Thursday, 4/5/2007 11:58:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE
Job Number : 31691	
Estimate Number : 10198	
P.O. Number : NIA	Part Number : D21752-1
This Issue : 4/5/2007 S.O. No. : NIA	Drawing Number : D2175 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : NIA	Drawing Revision : E
Previous Run : 31441	Material : NIA
Written By : <u> </u>	Due Date : 4/30/2007
Checked & Approved By : <u> </u>	Qty: 30 Um: Each
Comment : Est E 04-06-09 Reformat KJ/RF	
Est Rev:F 06-04-28 Manufactured on Water Jet JLM	
Est Rev:G As per Rev E 06-11-22 JLM	

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S063	2024-T3 .063 sheet
		
Comment: Qty.: 0.4958 sf(s)/Unit Total : 14.8743 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.063" thick (M2024T3S.063) Batch: <u>M103321</u> <u>SAD 07/05/17</u> <u>30</u>		
2.0	WATER JET	FLOW WATER JET
		
Comment: FLOW WATER JET 1-Cut as per Dwg D2175 Dwg Rev: <u>E</u> Prog Rev: <u>E</u> 2-Deburr if necessary <u>SAD 07/05/17</u> <u>30</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>SAD 07/05/17</u> <u>30</u>		
4.0	QC8	SECOND CHECK
		
Comment: SECOND CHECK <u>20705.22 (30)</u> <u>counted.</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack <u>SAD 07/05/17</u> <u>(30)</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: (D) Date: 07/05/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/5/2007 11:58:57 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31691

Part Number: D21751-1

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

BRAKE NC

NC BRAKE



(PTD)

Comment: NC BRAKE

Form as per Dwg D2175

SB 07/05/23

(40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



(41)

Comment: INSPECT WORK TO CURRENT STEP

07/05/24

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL/BL

07/05/24

(42)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

07/05/24

(40)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/24

(41)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(41)

Comment: FINAL INSPECTION/W/O RELEASE

07/05/25

Job Completion

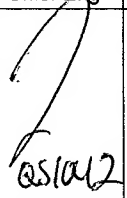
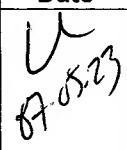

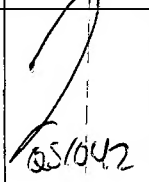
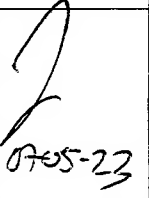


07/05/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070523	6.0	Parts were bent as -1, operator error, did not focus on what side, and bent the whole stack	 QS/042	This W/O is now Qty 40, AS -1, from W/O 31690	 07-05-23	 0705-23	 QS/042	 0705-23

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	31691
Description: Angle		Part Number:	D2175-1/2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		M-T / Vern	
R0.35	+/-0.030	R-0.35	✓		R-G	
2.915	+/-0.010	2.922	✓		Vern	
50°	+/-0.5°	50°	✓		Angle Borel Protractor	
0.300	+/-0.010	0.304	✓		Vern	
1.050 Pitch	+/-0.010	1.052	✓		Vern	
10.500	+/-0.010	10.501	✓		Vern	
11.550	+/-0.010	11.551	✓		Vern	
0.550	+/-0.010	0.547	✓		Vern	
0.900	+/-0.010	0.904	✓		Vern	
0.063 thick	+/-0.010	0.061	✓		Vern	
Grain Direction	N/A		✓			
Ø0.128	+0.005/-0.001	Ø0.130	✓		Vern	
Ø0.172	+0.005/-0.001	Ø0.173	✓		Vern	

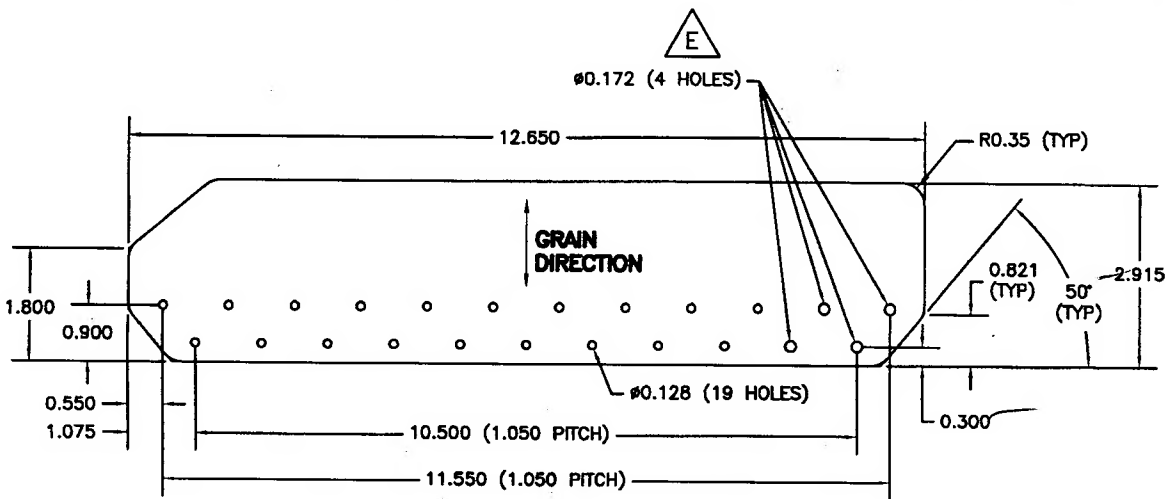
Measured by:	Sho	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	07/05/12	Date:	07/05/12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	[Signature]

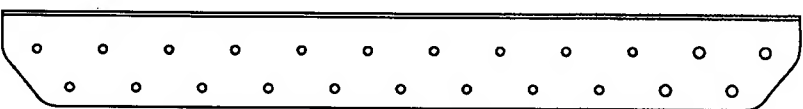


RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
RF	CE		
CHECKED PH	APPROVED [Signature]	DRAWING NO.	REV. E
		D2175	SHEET 1 OF 1
DATE 06.09.25		TITLE ANGLE	SCALE 1:3
A	95.10.25	NEW ISSUE	
B	96.01.18	CHANGED DIMENSION	
C	00.09.11	UPDATE FINISH SPEC	
D	04.06.03	RE-DESIGN	
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES	



D2175-1F FLAT PATTERN



NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE

WORK ORDER
NO. 31691

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